

*Split*

Work Order ID 81942-2

\*81942\*

Page 1

March-21-12 9:52:31 AM

Item ID: D4545-041

Accept

\*N9000040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Retainer, Inner, LH (Lower)

Stop

\*NS2\*

Start Date: 21/03/2012 Start Qty: 2.00

\*2\*

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 2.00

\*2\*

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/03/12* Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4545	B								

100

Pick Kit

0.00

\*100\*

Packaging

Memo

0.00

Packaging

110

0.00

\*110\*

Small Fab

Memo

0.00

Small Fab

1- ASSEMBLE AND BEND TABS AS PER DWG

2- TRANSFER DRILL HOLES AS PER DWG.

3- DISASSEMBLE AND DEBURR

4- DIMPLE HOLES AS PER DWG

*SB 12/03/12*

*① FF 12-03-22*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Work Order ID 81942

**\*81942\***

Page 2

March-21-12 9:52:31 AM

Item ID: D4545-041

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Retainer, Inner, LH (Lower)

Start Date: 21/03/2012 Start Qty: 2.00

**\*2\***

Cust Item ID:

Required Date: 04/04/2012 Req'd Qty: 2.00

**\*2\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC5- Inspect part completeness to step on W/O	0.00							
<b>*120*</b>									
QC	Memo	0.00							
Quality Control									
130	Chemical Conversion Coat per QSI005 4.1	0.00							
<b>*130*</b>									
HandFinish	Memo	0.00							
Hand Finishing									
140	QC7-Inspect Chemical Conversion Coat	0.00							
<b>*140*</b>									
QC	Memo	0.00							
Quality Control									

② B 1203 22

2 A 123 22

2X DM-12/23/22

PTO

# Dart Aerospace Ltd

W/O: 8942		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
1203-22	145 146	Install nutplates before paint  Permanent Change	[Signature]	1202-22	2	[Signature] CAREW	[Signature] 1202-22

Part No: D4545-041 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 81942

**\*81942\***

Page 3

March-21-12 9:52:31 AM

Item ID: D4545-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Retainer, Inner, LH (Lower)  
 Start Date: 21/03/2012 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 04/04/2012 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
<b>*150*</b>	<i>See below</i>					2	0	(20)	12/03/23.
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <u>10h35</u> OVEN TEMPERATURE: <u>320°F</u> FINISH TIME: <u>11h05</u>								m115128.
160	QC3- Inspect Part Finish	0.00							
<b>*160*</b>						2		Bl 12.3-23.	
QC	Memo	0.00							
Quality Control									
170		0.00							
<b>*170*</b>						(2)	FF	12-03-23	
Small Fab	Memo	0.00							
Small Fab	INSTALL NUT PLATES AS PER DWG								

*Step 145*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Work Order ID 81942

**\*81942\***

Page 4

March-21-12 9:52:31 AM

Item ID: D4545-041 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Retainer, Inner, LH (Lower)  
 Start Date: 21/03/2012 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 04/04/2012 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 <b>*180*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00				②			
190 <b>*190*</b> Packaging Packaging	Identify as per dwg & Stock Location: <u>442</u>  Memo	0.00  0.00				12/3/23		② sf	
200 <b>*200*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00				MLJ 12/03/26			ME 12-03-24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# Picklist Print

March-21-12 9:52:35 AM

Page 1

Work Order ID: 81942

\*81942\*

Parent Item: D4545-041

\*D4545-041\*

Parent Item Name: Retainer, Inner, LH (Lower)

Start Date: 21/03/2012

Required Date: 04/04/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 12.01.13 new issue DD verf:JLM  
12.02.27 AS PER DWG REV.B DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4541-1		Manufactured	No			100	Each	3.0000	1	2			
*D4541-1*									**	SB		12/03/22	
Bracket													
					<u>Location</u>					<u>Loc Qty</u>		<u>Loc Code</u>	
					FG					3		B 81260	
					78764					3			
D4542-1		Manufactured	No			100	Each	0.0000	1	2			
*D4542-1*													
Retainer, Inner, lh													
MS20426AD3-4		Purchased	No			170	Each	3,914.000	40	80			
*MS20426AD3-4*									**			② FF 12-03-23	
RIVET													
					<u>Location</u>					<u>Loc Qty</u>		<u>Loc Code</u>	
					ST316					3914		86	
					104374					1006			
					110398					2908			
MS21059L3K		Purchased	No			170	Each	0.0000	19	38			
*MS21059L3K*					712114				**	38		② FF 12-03-23	
Nutplate													
MS21061L3K		Purchased	No			170	Each	49.0000	1	2			
*MS21061L3K*									**			② FF 12-03-23	
NUT PLATE													
					<u>Location</u>					<u>Loc Qty</u>		<u>Loc Code</u>	
					ST303					49		2	
					120242					49			

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

ITEM	QTY	QTY	QTY	QTY	QTY	QTY	QTY	QTY	PART NUMBER	DESCRIPTION
	X								D4545-041	RETAINER, LH INNER (LOWER)
		X							D4545-042	RETAINER, RH INNER (LOWER)
			X						D4545-043	RETAINER, LH INNER (SIDE)
				X					D4545-044	RETAINER, RH INNER (SIDE)
					X				D4545-045	RETAINER, LH INNER (TOP CORNER)
						X			D4545-046	RETAINER, RH INNER (TOP CORNER)
							X		D4545-047	RETAINER, LH INNER (TOP)
								X	D4545-048	RETAINER, RH INNER (TOP)
1	1								D4541-1	BRACKET
2		1							D4541-2	BRACKET
3			1	1					D4541-3	BRACKET
4					1	1			D4541-5	BRACKET
5							1	1	D4541-7	BRACKET
6	1								D4542-1	RETAINER
7		1							D4542-2	RETAINER
8			1	1					D4542-3	RETAINER
9					1	1			D4542-5	RETAINER
10							1	1	D4542-7	RETAINER
11	40	38	28	28	12	12	16	16	MS20426AD3-4	RIVET
12	19	18	14	14	6	6	8	8	MS21059L3K	NUTPLATE
13	1	1							MS21061L3K	NUTPLATE

# NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: PRIOR TO ASSEMBLY, POWDER COAT D4541-X & D4542-X WITH BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N & B/N PER DART QSI 044 6.1
- 7) WEIGHT: -041/-042 = 0.38 lbs, -043/-044 = 0.27 lbs,  
-045/-046 = 0.11 lbs, -047/-048 = 0.15 lbs
- 8) BEND INDIVIDUAL TABS ON D4541-X BRACKETS TO CORRESPONDING "A#" (A1, A2, ETC.,) VALUE

B	ADD FINISH (ZN A8-1)	CP	12.02.01
A	NEW ISSUE	CP	12.01.09
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.02.01		

**DART AEROSPACE LTD**  
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. D4545  
SHEET 1 OF 9

TITLE  
RETAINER, INNER

SCALE  
NTS

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8194212/02121

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2012-02-16

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

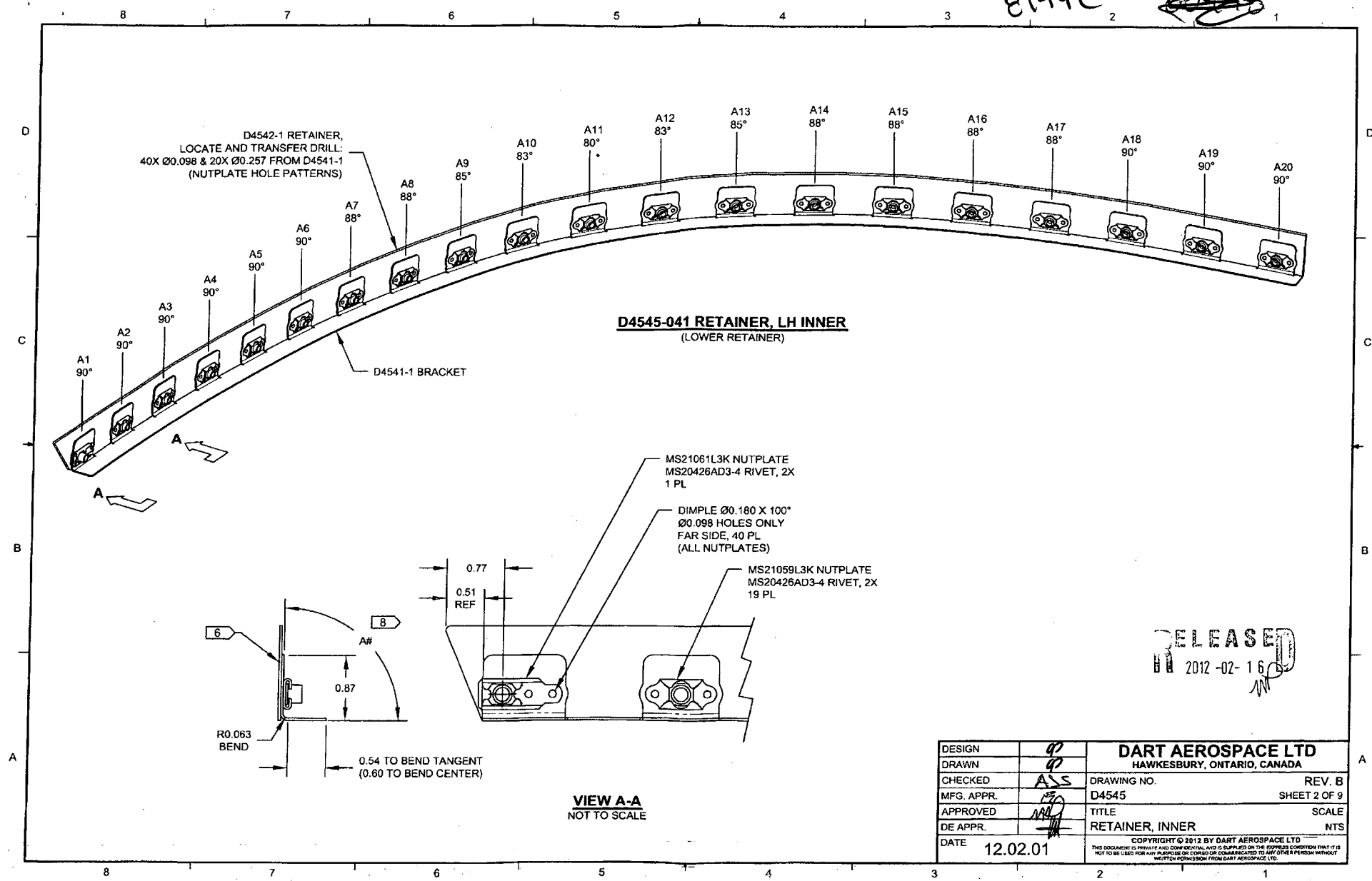
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

81942 ~~801942~~



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2012-02-16

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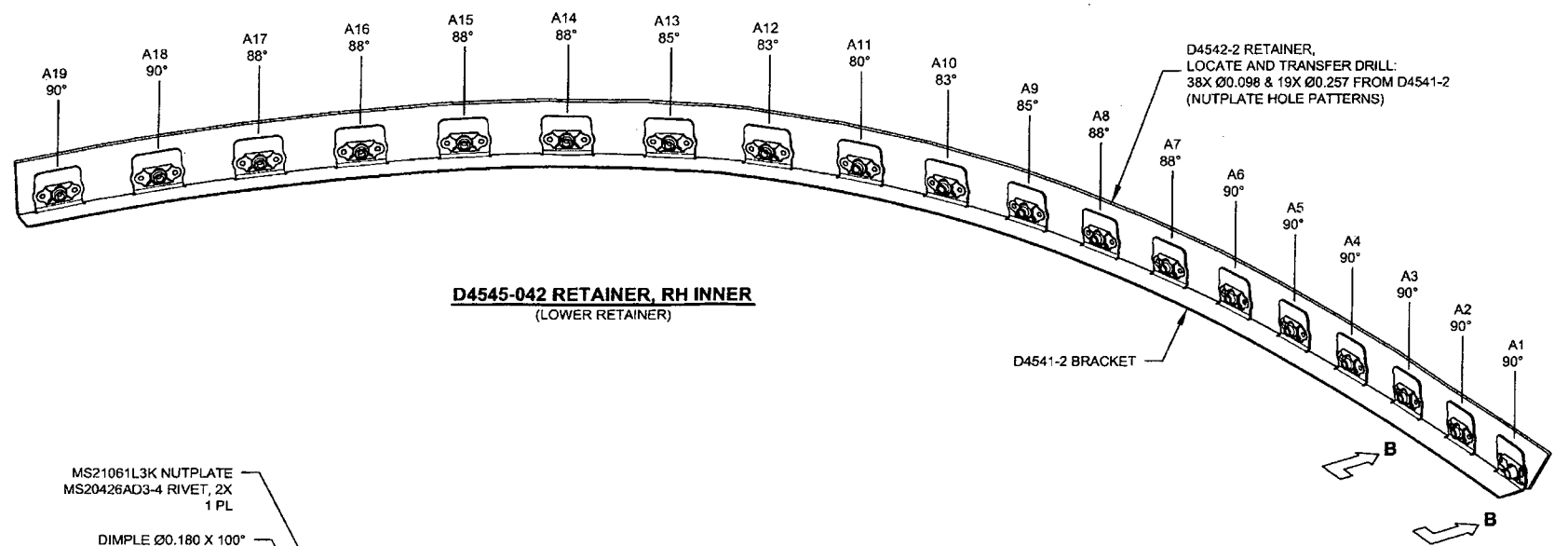
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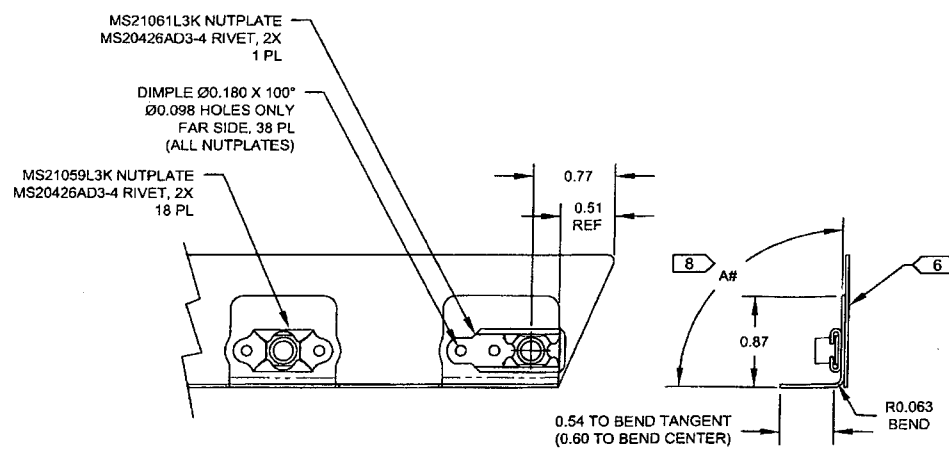
**NOTE:** Date & initial all entries

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~~80942~~



**D4545-042 RETAINER, RH INNER**  
(LOWER RETAINER)



**VIEW B-B**  
NOT TO SCALE

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2012-02-16

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MFG. APPR.	90	D4545	SHEET 3 OF 8
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W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

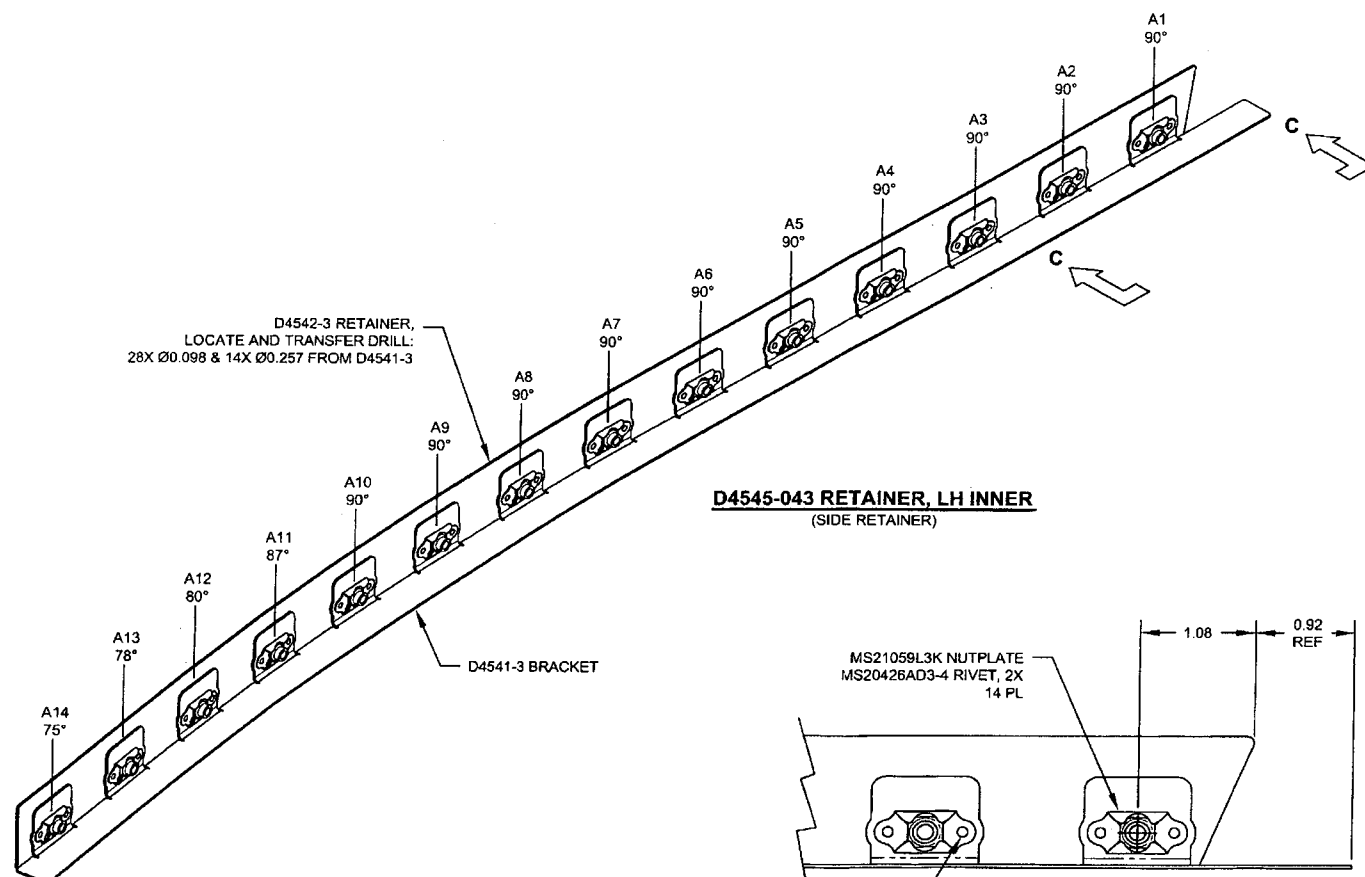
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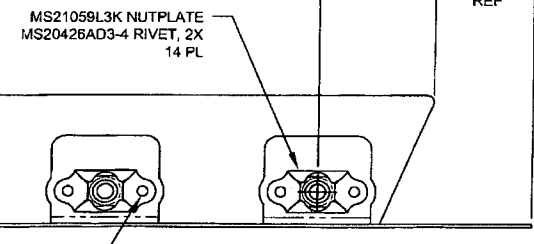
81942

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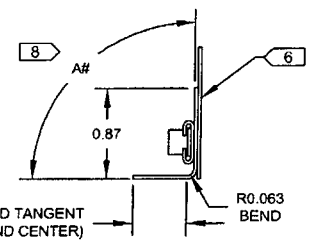


**D4545-043 RETAINER, LH INNER**  
(SIDE RETAINER)

DIMPLE Ø0.180 X 100°  
Ø0.098 HOLES ONLY  
FAR SIDE, 28 PL



**VIEW C-C**  
NOT TO SCALE



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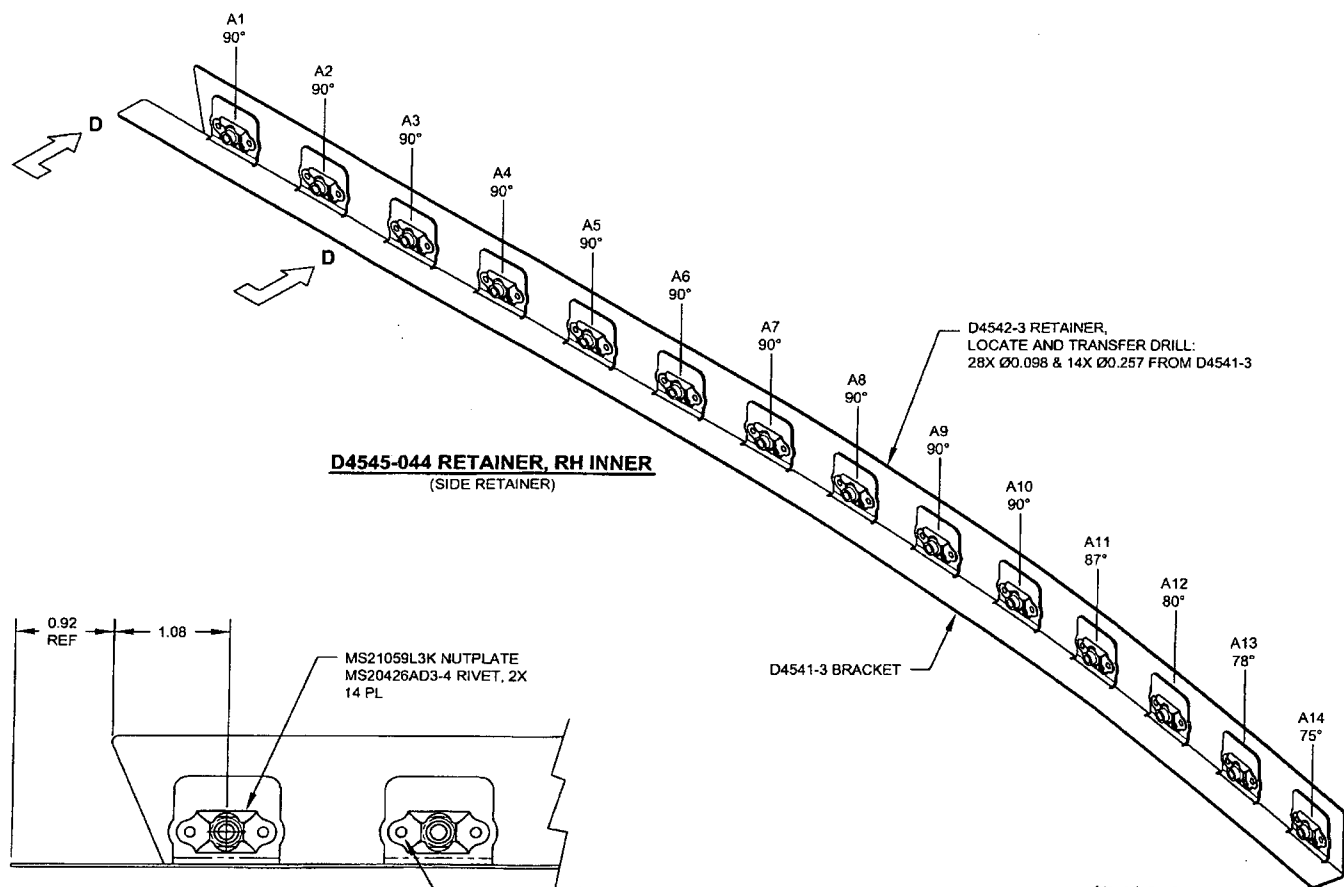
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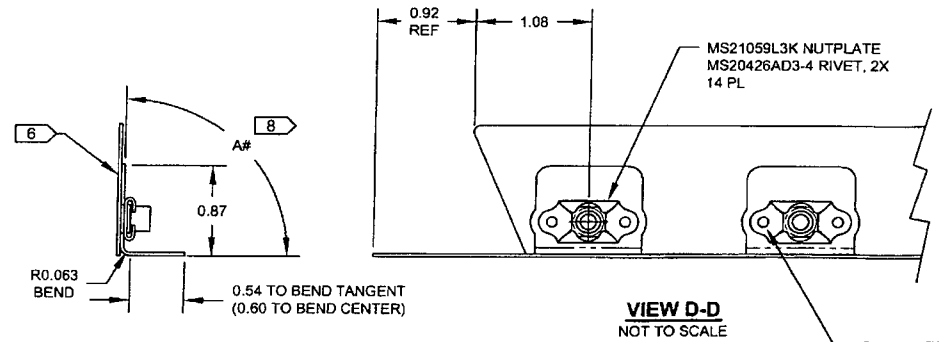
**NOTE:** Date & initial all entries

81942

~~80488~~



**D4545-044 RETAINER, RH INNER**  
(SIDE RETAINER)



**VIEW D-D**  
NOT TO SCALE

RELEASED  
2012-02-16

DESIGN	92	<b>DART AEROSPACE LTD</b>	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.		D4545	SHEET 5 OF 9
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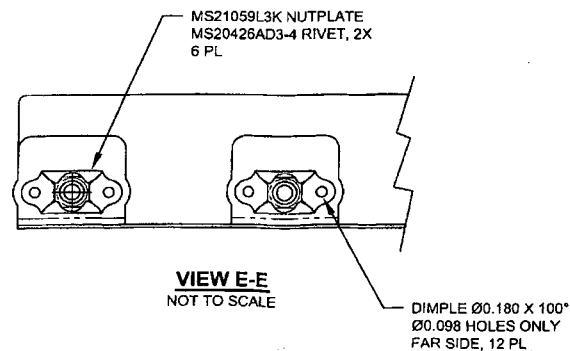
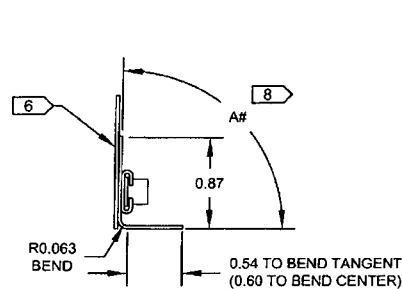
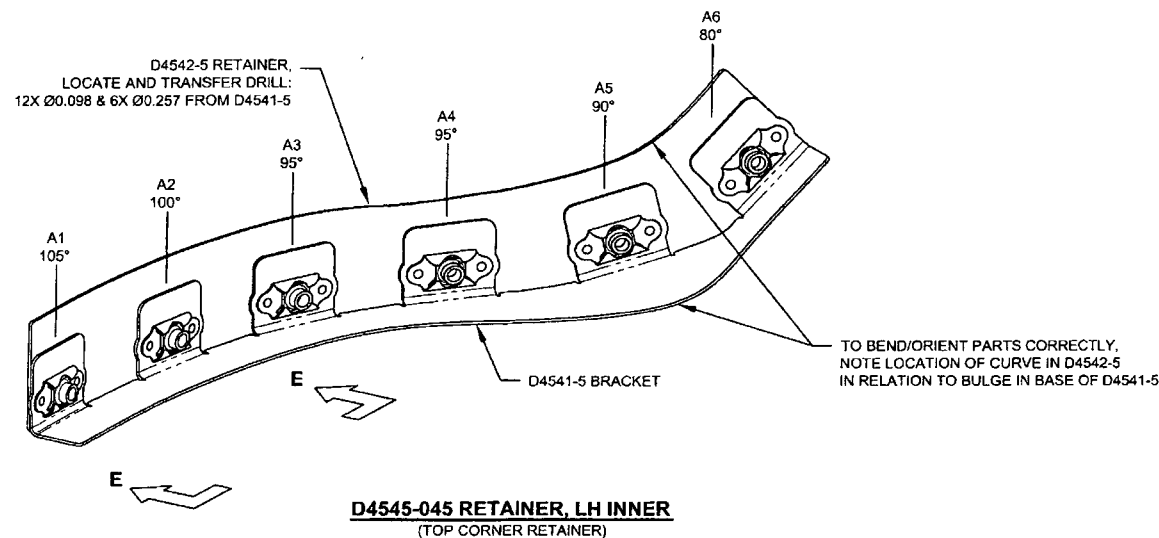
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

81942 ~~854100~~



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2012-02-16

DESIGN		<b>DART AEROSPACE LTD</b>
DRAWN		HAWKESBURY, ONTARIO, CANADA
CHECKED	ASS	DRAWING NO. REV. B
MFG. APPR.		D4545 SHEET 6 OF 9
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DE APPR.		RETAINER, INNER NTS
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

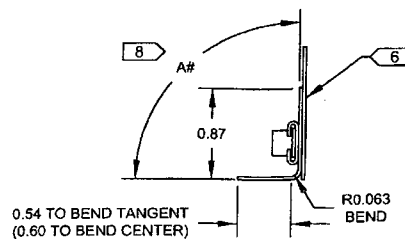
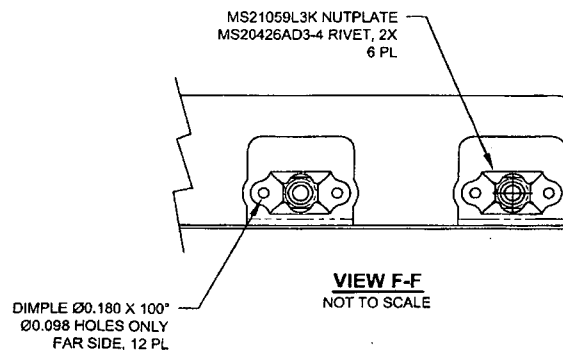
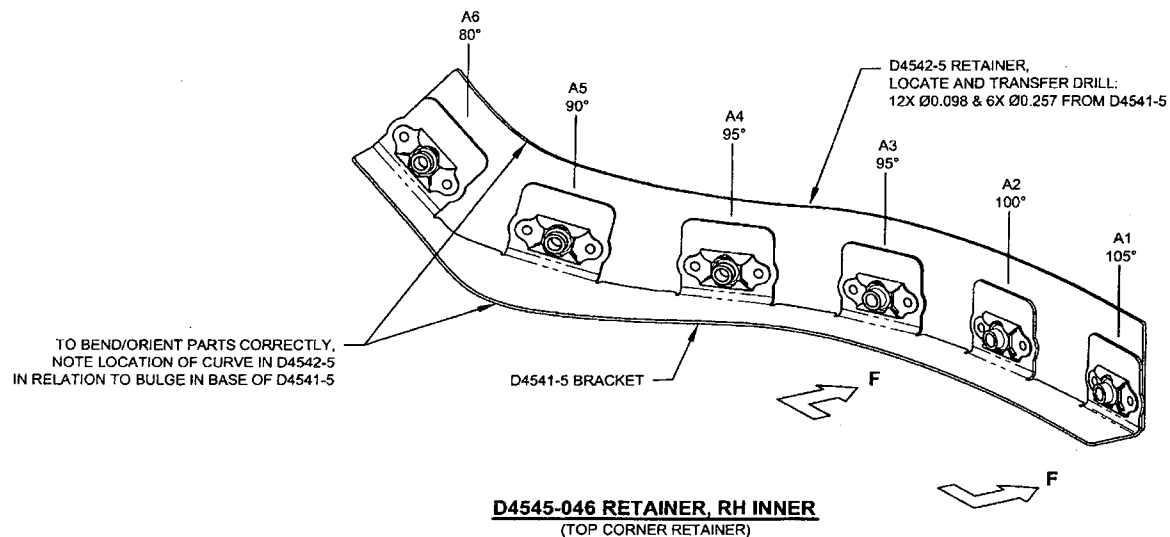
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

81942-20198



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2012-02-16

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4545	SHEET 7 OF 9
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

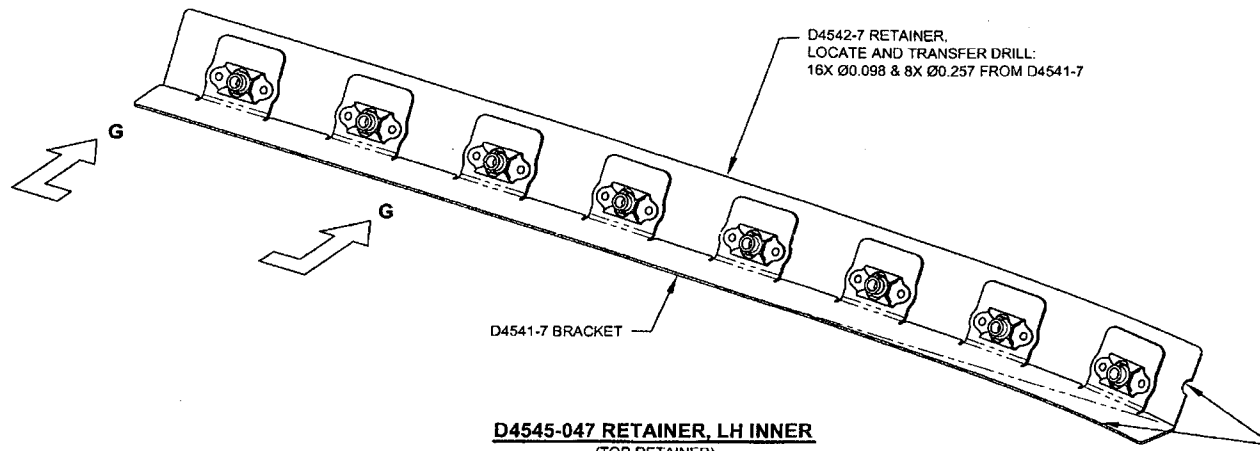
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

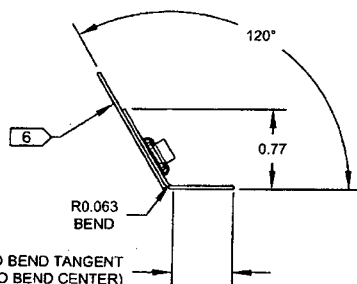


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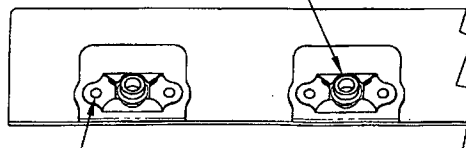


**D4545-047 RETAINER, LH INNER**  
(TOP RETAINER)

TO BEND/ORIENT PARTS CORRECTLY,  
NOTE LOCATION OF TOOLING MARK IN D4542-7  
IN RELATION TO CURVE IN BASE OF D4541-7



MS21059L3K NUTPLATE  
MS20426AD3-4 RIVET, 2X  
8 PL



DIMPLE Ø0.180 X 100°  
Ø0.098 HOLES ONLY  
FAR SIDE, 16 PL

**VIEW G-G**  
NOT TO SCALE

RELEASE  
2012-02-16

DESIGN	90	<b>DART AEROSPACE LTD</b>	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ALS	DRAWING NO.	REV. B
MFG. APPR.	13	D4545	SHEET 8 OF 9
APPROVED	13	TITLE	SCALE
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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

819,42

TO BEND/ORIENT PARTS CORRECTLY,  
NOTE LOCATION OF TOOLING MARK IN D4542-7  
IN RELATION TO CURVE IN BASE OF D4541-7

D4542-7 RETAINER,  
LOCATE AND TRANSFER DRILL:  
16X Ø0.098 & 8X Ø0.257 FROM D4541-7

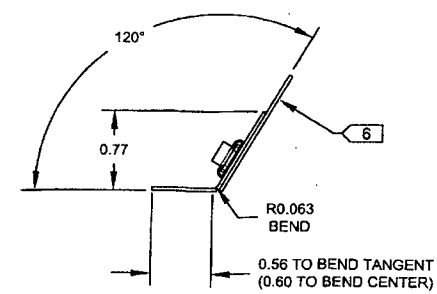
D4541-7 BRACKET

**D4545-048 RETAINER, RH INNER**  
(TOP RETAINER)

MS21059L3K NUTPLATE  
MS20426AD3-4 RIVET, 2X  
8 PL

DIMPLE Ø0.180 X 100°  
Ø0.098 HOLES ONLY  
FAR SIDE, 16 PL

**VIEW H-H**  
NOT TO SCALE



RELEASED  
2012-02-16  
JP

DESIGN	90	<b>DART AEROSPACE LTD</b>	
DRAWN	90	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. B
MFG. APPR.	90	D4545	SHEET 9 OF 9
APPROVED	90	TITLE	SCALE
DE APPR.	90	RETAINER, INNER	NTS
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**Dart Aerospace Ltd**

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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries